

March-06-14 7:56:04 AM

1 14464

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 3/06/14 **Start Qty:** 1.00 ***1***

Required Date: 3/14/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Draw Nbr	Revision Nbr	
D2842	Rev B	

0.00

100

Large Fab

0.00

Large Fab

Memo

Large Fab

- 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
- 2-Drill D2842-1 using Jig DT8271 as per Dwg D2842
- 3-Deburr and bevel ends for welding

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

120

Weld per dwg A/R Aluminum rod Batch: M163385 0.00

0.00

120

Large Fab

Memo

0.00

Large Fab

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per
Dwg D2842

2-Grind end cap weld flush

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Hand Finishing

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
1	0	14-0321	DAS 18 9-83

[Handwritten signature]

1 0
1 25 14.43

~~DAY~~
~~19~~
9-89

14.04.03

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 3/06/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/14/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00				1	1		DAS 19 9-89 14-04-03
160									
QC	Memo	0.00							
Quality Control									
170	Weld per dwg A/R Aluminum rod Batch: <u>125127</u>	0.00				1	1		14-04-03
170									
Large Fab	Memo	0.00							
Large Fab	1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.								
180	QC10- Inspect visual per QSI004- ground welds	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
14/4/14

er

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Assembly, 206 Float
Start Date: 3/06/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/14/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *100* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 9-89 M4/7							
191 *101* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo ***Touch up step with alodine per qsi 005 prior to powder coat***	0.00 0.00				1	76	14-4-7	
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M128077 Memo START TIME: 810 OVEN TEMPERATURE: 320° FINISH TIME: 340	0.00 0.00				1	d	14-4-10	DAS 34 9-89

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 3/06/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/14/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00				1	2	20	14/04/10
210									
QC	Memo	0.00							
Quality Control									
220	HandFinishing	0.00				1	2	20	14/04/11
220									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D2842								
	2-Wing Walk as per Dwg D2842 and QSI 005 4.1								
	Batch: <u>128623</u>								
230	QC5- Inspect part completeness to step on W/O	0.00				1			
230									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
14/4/14

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Item ID: D2842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 3/06/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/14/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location:	0.00				DAS 31 9-89		1	
240									
Packaging	Memo	0.00							
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

MLJ 14-05-01

14-4-30

Picklist Print

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Page 1

Work Order ID: 114464

114464

Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 3/06/14

Required Date: 3/14/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

120

Each

158.0000

1

1

D2622-120C

Step Extrusion

① 14-03-23 PD

Location

Loc Qty

Loc Code

HALL

153

105575

41

109575

112

WA003

5

①01765

5

D2734

Manufactured

No

120

Each

125.0000

2

2

D2734

Step End Plate

① 14-03-31 PD

Location

Loc Qty

Loc Code

WA003

125

①05712

65

99709

60

D3459-1

Manufactured

No

220

Each

16.0000

2

2

D3459-1

Float Step Mounting Plate

② 14-03-23 PD

Location

Loc Qty

Loc Code

WA003

16

①13198

16

B113244 → 1

1

Picklist Print

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 3/06/14

Required Date: 3/14/14

Start Qty: 1.00

Required Qty: 1.00

D3459-3 Manufactured No

120 Each 34.0000 2 2

D3459-3

Float Step Mounting Plate

② 14-03-25 DD

Location

Loc Qty

Loc Code

WA003

34

110702

2

113052

20

113241

12

2

MS27039C1-07 Purchased No

220 Each 56.0000 3 3

MS27039C1-07

screw

3

② 14/04/10

Location

Loc Qty

Loc Code

ST308

56

124580

6

m127305

50

NAS1149C0332R Purchased No

100 Each 7,728.000 3 3

NAS1149C0332R

WASHER

3

② 14/04/10

Location

Loc Qty

Loc Code

GA

1125

125654

1125

st510

6603

m126319

89

m127306

2500

m127410

3000

m127831

1014

128591

3

Picklist Print

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Work Order ID: 114464

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 3/06/14

Required Date: 3/14/14

Start Qty: 1.00

Required Qty: 1.00

NAS1329C3KB130

Purchased

No

220

Each

74.0000

3

3

NAS1329C3KB130

3

SP

14/04/10

insert

Location

Loc Qty

Loc Code

FP001

74

m126410

24

m127836

50

NAS1515H3L

Purchased

No

220

Each

350.0000

3

3

***NAS1515H3I ***

3

SP

14/04/10

Washer

Location

Loc Qty

Loc Code

FG

36

102472

36

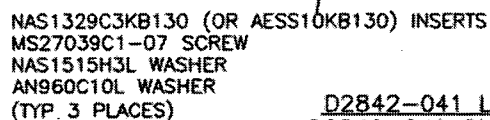
ST297

314

m127831

314

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NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

QTY -D41	QTY -D42	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AE5S10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN950C 10L	WASHER

Technical drawing of a cross-section of a beam. The beam has a horizontal top flange and a vertical web. The end of the beam is reinforced with a plate labeled "D2734 END PLATE". This plate is attached to the bottom of the web and extends downwards and outwards at an angle of 45.0° from the horizontal. A dimension line indicates the 45.0° angle. A vertical dimension line on the right indicates a height of 1.000. A horizontal dimension line at the bottom indicates a width of 1.000. A small circle is located at the bottom left corner of the beam's cross-section.

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-11-14

DA RT

		DARI AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D2842	<u>REV. B</u> SHEET 1 OF 1
DATE 05.09.23		TITLE 206L/407 FLOAT STEP ASSEMBLY	SCALE NTS
A	98.10.13	NEW ISSUE	
B	05.09.23	RE-DESIGN, ADD D3459-1/-3	

